

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005309**Date Inspected:** 22-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG COMPONENT				

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

**Ultrasonic Testing(Gate To Gate)**

The QA Inspector performed, (along with ABF technician Mr.Wang Zhenhua and Mr.Ding Baohua), gate to gate Ultrasonic Testing (UT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations. The QA Inspector generated a field inspection UT report on this date designating areas of rejectable indications. Panel identification number are DP-145-001 ,DP-247-001, DP-466-001, DP-220-001, DP-385-001 and DP-170-001.

The Y locations of indication for the panel were marked and recorded as:

DP-145-001 (7EW)

Total Number of Ribs -05

Total Number of Tack Welds - 240

Total Number of Tack Welds Scanned – 240

Weld 01: Tack Welds Scanned - 24, Indication Observed - 09

Weld 02: Tack Welds Scanned - 24, Indication Observed - 04

Weld 03: Tack Welds Scanned - 24, Indication Observed - 03

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 4 )

---

Weld 04: Tack Welds Scanned - 24, Indication Observed - 01  
Weld 05: Tack Welds Scanned - 24, Indication Observed - 08  
Weld 06: Tack Welds Scanned - 24, Indication Observed - 07  
Weld 07: Tack Welds Scanned - 24, Indication Observed - 08  
Weld 08: Tack Welds Scanned - 24, Indication Observed - 06  
Weld 09: Tack Welds Scanned - 24, Indication Observed - 08  
Weld 10: Tack Welds Scanned - 24, Indication Observed - 06

DP-247-001 (6BW)

Total Number of Ribs -05

Total Number of Tack Welds - 220

Total Number of Tack Welds Scanned – 220

Weld 01: Tack Welds Scanned - 22, Indication Observed - 03  
Weld 03: Tack Welds Scanned - 22, Indication Observed - 01  
Weld 04: Tack Welds Scanned - 22, Indication Observed - 02  
Weld 05: Tack Welds Scanned - 22, Indication Observed - 02  
Weld 06: Tack Welds Scanned - 22, Indication Observed - 03  
Weld 07: Tack Welds Scanned - 22, Indication Observed - 02  
Weld 08: Tack Welds Scanned - 22, Indication Observed - 03  
Weld 09: Tack Welds Scanned - 22, Indication Observed - 05  
Weld 10: Tack Welds Scanned - 22, Indication Observed – 03

DP-220-001 (6BW)

Total Number of Ribs -05

Total Number of Tack Welds - 220

Total Number of Tack Welds Scanned – 220

Weld 03: Tack Welds Scanned - 22, Indication Observed - 01  
Weld 04: Tack Welds Scanned - 22, Indication Observed - 03  
Weld 05: Tack Welds Scanned - 22, Indication Observed - 01  
Weld 06: Tack Welds Scanned - 22, Indication Observed - 01  
Weld 09: Tack Welds Scanned - 22, Indication Observed - 01  
Weld 10: Tack Welds Scanned - 22, Indication Observed - 01

DP-466-001 (7BE)

Total Number of Ribs -05

Total Number of Tack Welds - 260

Total Number of Tack Welds Scanned – 260

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 4 )

---

Weld 02: Tack Welds Scanned - 26, Indication Observed - 01  
Weld 03: Tack Welds Scanned - 26, Indication Observed - 05  
Weld 04: Tack Welds Scanned - 26, Indication Observed - 03  
Weld 05: Tack Welds Scanned - 26, Indication Observed - 01  
Weld 06: Tack Welds Scanned - 26, Indication Observed - 01  
Weld 07: Tack Welds Scanned - 26, Indication Observed - 01  
Weld 08: Tack Welds Scanned - 26, Indication Observed - 02  
Weld 09: Tack Welds Scanned - 26, Indication Observed - 04  
Weld 10: Tack Welds Scanned - 26, Indication Observed - 03

DP-385-001 (7BE)

Total Number of Ribs -05

Total Number of Tack Welds - 260

Total Number of Tack Welds Scanned – 260

Weld 01: Tack Welds Scanned - 26, Indication Observed - 09  
Weld 02: Tack Welds Scanned - 26, Indication Observed - 09  
Weld 03: Tack Welds Scanned - 26, Indication Observed - 08  
Weld 04: Tack Welds Scanned - 26, Indication Observed - 07  
Weld 05: Tack Welds Scanned - 26, Indication Observed - 08  
Weld 06: Tack Welds Scanned - 26, Indication Observed - 07  
Weld 07: Tack Welds Scanned - 26, Indication Observed - 12  
Weld 08: Tack Welds Scanned - 26, Indication Observed - 13  
Weld 09: Tack Welds Scanned - 26, Indication Observed - 15  
Weld 10: Tack Welds Scanned - 26, Indication Observed - 06

DP-170-001 (7CW)

Total Number of Ribs -05

Total Number of Tack Welds - 260

Total Number of Tack Welds Scanned – 182

Weld 04: Tack Welds Scanned - 26, Indication Observed - 04  
Weld 05: Tack Welds Scanned - 26, Indication Observed - 05  
Weld 06: Tack Welds Scanned - 26, Indication Observed - 03  
Weld 07: Tack Welds Scanned - 26, Indication Observed - 06  
Weld 08: Tack Welds Scanned - 26, Indication Observed - 02  
Weld 09: Tack Welds Scanned - 26, Indication Observed - 05  
Weld 10: Tack Welds Scanned - 26, Indication Observed - 02

100% of UT Gate To Gate for Deck Panel (DP-170-001 )Tack welds was not completed during this inspection shift.

Remaining Weld to be completed W1,W2,W3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

---

## WELDING INSPECTION REPORT

( Continued Page 4 of 4 )

---

documents.

### Summary of Conversations:

No relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

---